

**Work Order ID 64549**

Page 1

Wednesday, December 08, 2010 10:11:58 A

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *PJ*

Date: 10-12-8

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3315	Rev B	

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

1010 .060

Memo

1-Cut as per Dwg D3315  Dwg Rev: *B*  Prog Rev: *B*  2-  
Deburr if necessary*B10-12-23*

(2)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

120



QC8- Inspect parts - second check

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 64549**

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form using DT8179 Die and DT8157 as per Dwg D3315Rev: B

SB 11/01/03

(2)

140



QC6- Inspect dimensions to drawing

0.00

SB 11/02/03

QC

Memo

0.00

Quality Control

(X2)

150



Large Fab

0.00

(X2)

Large Fab

Memo

0.00

(X2)

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev:

<input type="checkbox"/> Qty	Part Number	Description	Batch	<input type="checkbox"/> A/R
N/A	7560 Hardcoat Rod	M11552		

11-1-11

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Item ID: D3315-3

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Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC10- Inspect visual per QSI004- ground welds

0.00

S 11/01/12

QC

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

S 11/01/12

QC

Quality Control

180



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Powdercoat

Powder Coating

M 110538

Memo

START TIME:

320

2120

OVEN TEMPERATURE:

250

FINISH TIME:

0.00

2 Bl 11-01-13.

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 64549**

Wednesday, December 08, 2010 10:11:58 A



Page 4

Item ID: D3315-3

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 2.00

Required Date: 12/22/2010 Req'd Qty: 2.00

Accept



Setup Start



Stop



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

QC3- Inspect Part Finish

0.00

2 d M u o l 1 4

Quality Control

200



Packaging

Packaging

0.00

11/11/14 24

Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following:  
 TCCA-PDA, Dart Aerospace Ltd.  P/N: D3315-3, B/N: BXXXXXX  For Product Eligibility see PDA04-17  and Stock  Location: 49B

210



QC

QC21- Final Inspection - Work Order Release

0.00

11/01/14 J

Quality Control

Memo

0.00

11/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, December 08, 2010 10:12:03 AM

Work Order ID: 64549



Parent Item: D3315-3



Parent Item Name: Wearplate

Start Date: 12/8/2010

Required Date: 12/12/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A□05.05.12□New issue□KJ/JLM□  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased		No		100	sf	84.5250	2.296	4.833684		12/10-12-2010	

Location	Loc Qty	Loc Code
MAT19	84.525	
111410	84.525	111410

(2)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	6415419
Description: Wearplate		Part Number:	D3315-3
Inspection Dwg: D3315	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	X		TPG	
58.094	+/-0.010	58.094	Y		T	
51.368	+/-0.010	51.368	X		T	
44.531	+/-0.010	44.531	X		T	
37.719	+/-0.010	37.719	Z		T	
30.375	+/-0.010	30.375	X		T	
24.188	+/-0.010	24.188	X		T	
18.875	+/-0.010	18.875	X		T	
17.375	+/-0.010	17.375	X		T	
10.594	+/-0.010	10.594	Y		T	
5.375	+/-0.010	5.375	X		T	
0.875	+/-0.010	.877	X		VRB02	
1.62	+/-0.030	1.62	X		V	
5.214	+/-0.010	5.214	X		V	
4.402	+/-0.010	4.404	Z		V	
3.550	+/-0.010	3.555	X		V	
Ø0.310	+0.006/-0.001	.301	Z		V	
Ø0.266 x 0.450	+/-0.010	Ø5X450	Z		V	

Measured by:	VB	Audited by:	S	Prototype Approval:	N/A
Date:	10-12-23	Date:	10/12/23	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	08.01.22	New Issue	KJ/EC/DD	VB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

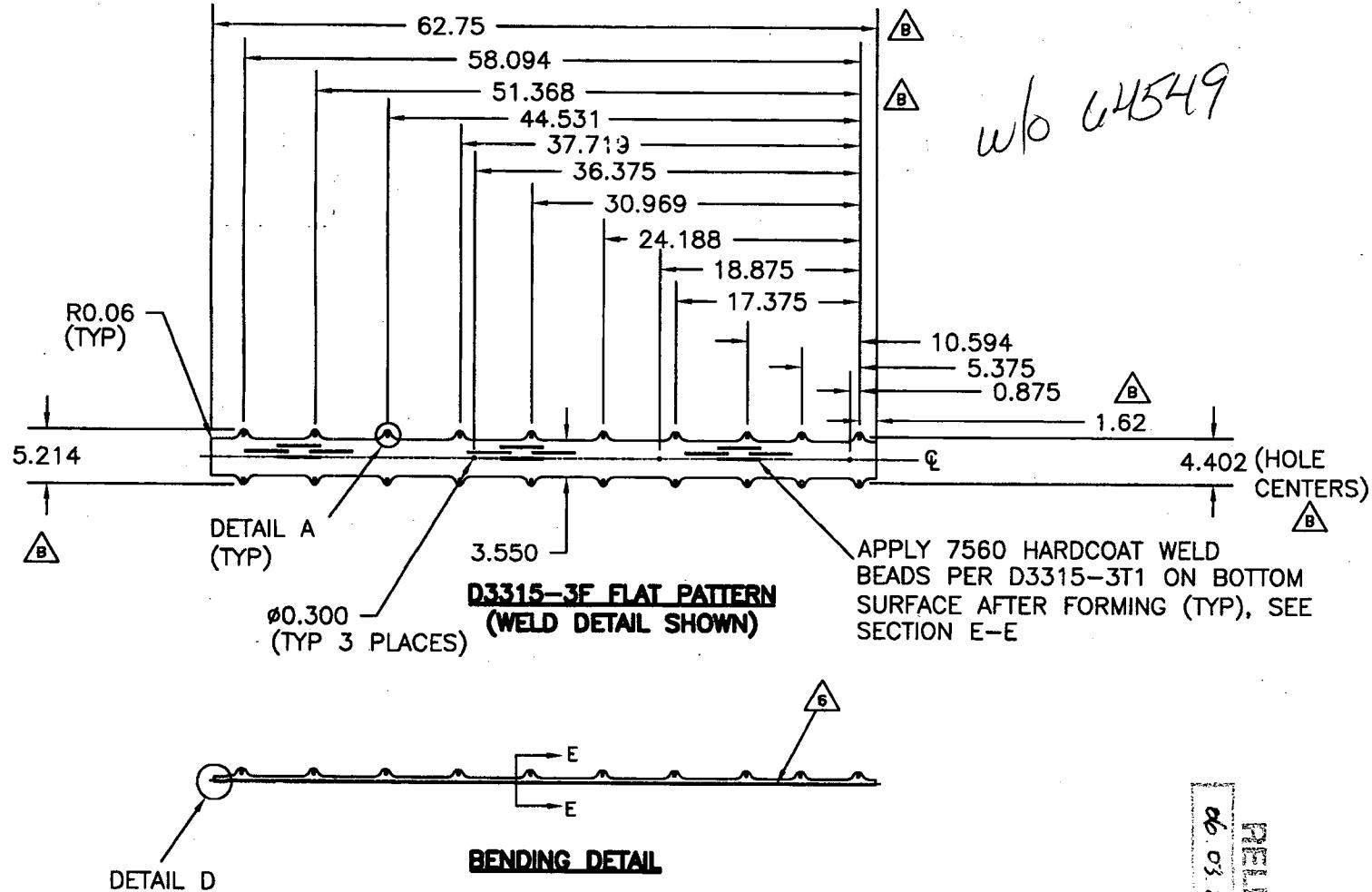
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NOTE: Date & initial all entries

w/o 64549

**DART**



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		SHEET 2 OF 4
06.01.31		D3315
		WEARPLATE
		SCALE 1:16

RELEASER  
06.03.20 *[Signature]*

**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

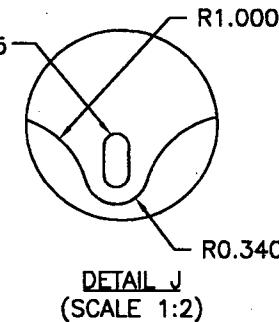
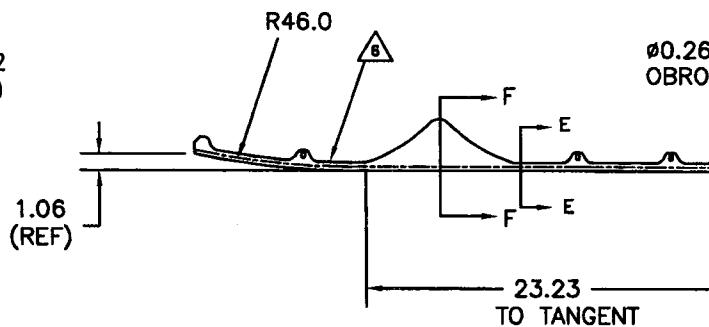
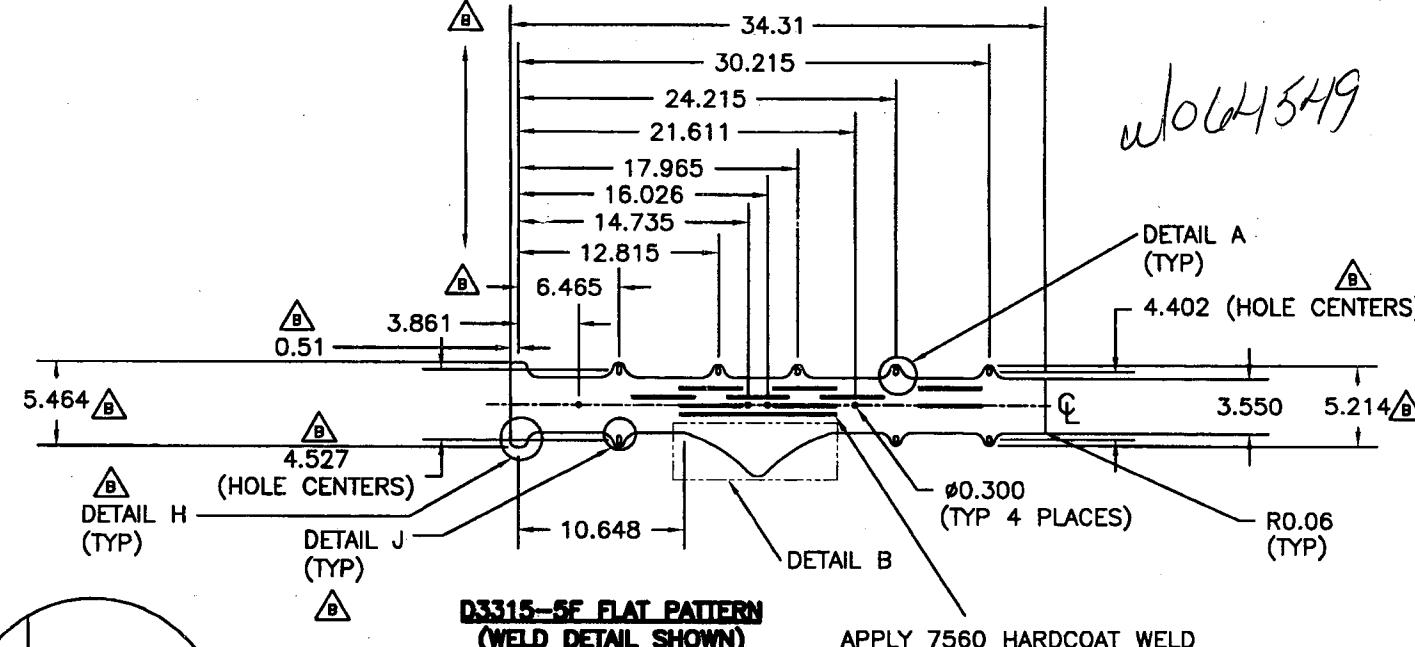
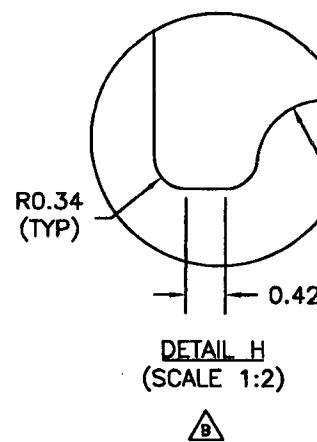
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>P/H</i>	DRAWN BY <i>P/H</i>	<b>DART AEROSPACE LTD</b>	
CHECKED <i>[initial]</i>	APPROVED <i>[initial]</i>	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315
SCALE	1:12	SHEET 3 OF 4	REV. B

RELEASED  
06.03.20 *[initial]*



**BENDING DETAIL**

**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
\*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXxxxx, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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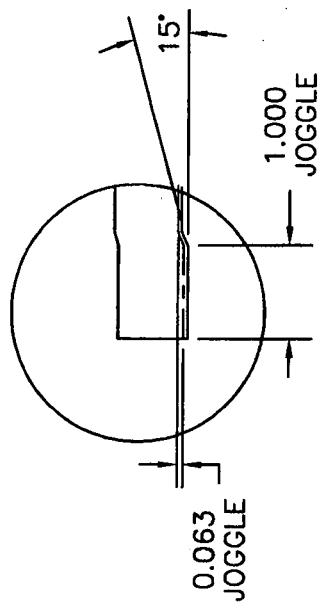
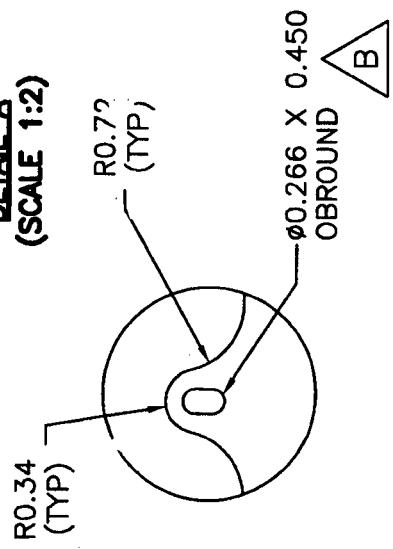
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

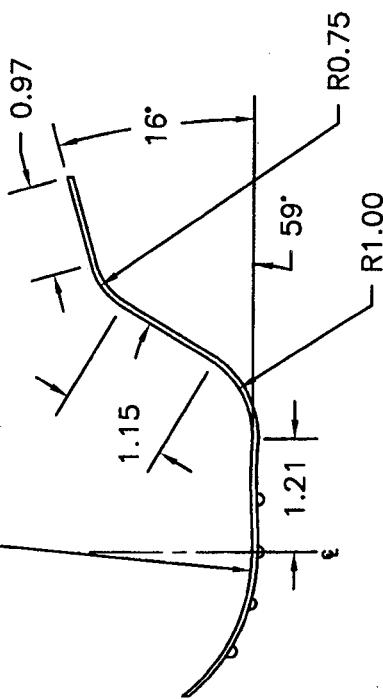
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**DETAIL A**  
(SCALE 1:2)

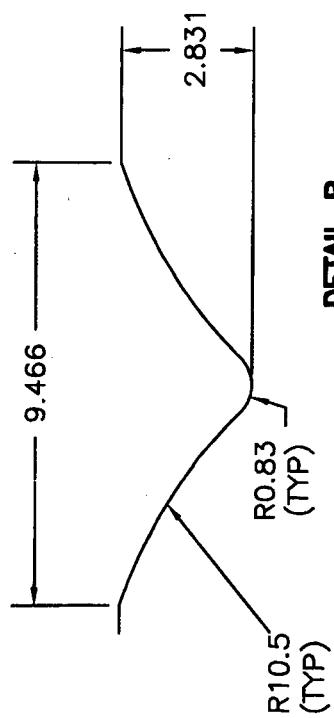


**DETAIL D**  
(SCALE 1:2)

R2.00<sup>+0.000</sup><sub>-0.000</sub>

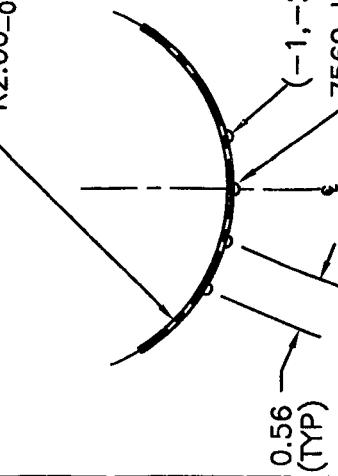


**SECTION F-F**  
(SCALE 1:2)



**DETAIL B**  
(SCALE 1:4)

R2.00<sup>+0.030</sup><sub>-0.000</sub>



**SECTION E-E**  
(SCALE 1:2)

RE: DART  
06.03.20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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